Date User:

Wednesday, 2/8/2006 7:06:50 AM

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 25732

Estimate Number P.O. Number

: 11464 :NIA

This Issue Prsht Rev.

First Issue

Written By

Previous Run

: 2/8/2006

: NC

· NIA

: NIA

: SMALL /MED FAB

S.O. No. : >1/1

COMMENT BELOW

Checked & Approved By

Comment

A02.04.30

New Issue NG

Drawing Name

Part Number

: D314089_ : D3140 REV D

: DOUBLER

Drawing Number Project Number

: N/A

Drawing Revision Material

Due Date

: D :NIA

: 2/15/2006

Qty:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M2024T3S032

Comment: Qty.: Total: 7.5247 sf(s) 1.8812 sf(s)/Unit

2024-T3 .032 sheet

Matl: 2024-T3 (QQ-A-250/4) .032" thick

(M2024T3S.032)

Batch_M 18147

2024-T3 .032 sheet

2.0



Comment: SHEAR

Cut blanks. ¿SBlank size: 6.00" x 43.00" x .032" thick

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA226

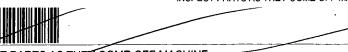
Deburr break all unmarked sharp edges .005 to 0.010

Stack of 15

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



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W/O:		WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	PAR #:	_ Fault Category:	 NCR: Yes No	DQA:	' Date: 💍	Solodó
			QA: N/C	Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B			A			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

Date: Wednesday, 2/8/2006 7:06:50 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: DOUBLER** 12 Job Number: 25732 Part Number: D314089 Job Number: Seq. #: **Description: Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 06-02-17 Chemical Conversion Coat as per QSI 005 4.1 7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 206/02/17 Location: DOCUMENT CONTROL 9.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Form: rprocess

Page 2

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDU	JRE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
		<u>0.</u>							
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Part No		PAR #: Fa	ault Category:			No DQ			,

art No.	PAR#	Fault Category:	NCR: Yes	NO	DQA:	Date:	
			QA: I	N/C C	losed:	Date:	

NCR:		· ·	VORK ORDE	R NON-CONFORMAN	CE (NCR)			-
		Description of NG	٠	Corrective Action Section B				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries